

CORRECTED VERSION

14 JAN 2005

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
22 January 2004 (22.01.2004)

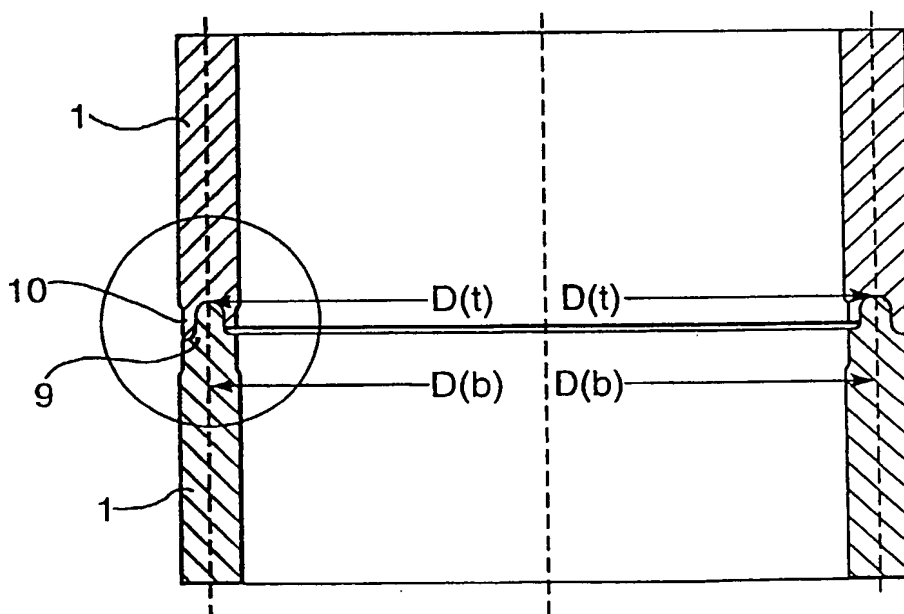
PCT

(10) International Publication Number
WO 2004/007139 A1

- (51) International Patent Classification⁷: B23K 33/00, 20/02, 20/14
- (21) International Application Number: PCT/EP2003/007787
- (22) International Filing Date: 17 July 2003 (17.07.2003)
- (25) Filing Language: English
- (26) Publication Language: English
- (30) Priority Data:
02077911.2 17 July 2002 (17.07.2002) EP
02077912.0 17 July 2002 (17.07.2002) EP
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[Continued on next page]

(54) Title: FORGE WELDING METHOD



(57) Abstract: A method for forge welding tubulars such that formation of upsets in the welding zone is minimized comprises shaping the tubular ends that are to be welded together into an inwardly sloping configuration such that when the tubular ends are heated during the forge welding process the heated tubular ends deform as a result of thermal expansion into a substantially longitudinally oriented cylindrical shape.

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